

Date:  
User:Friday, 9/7/2007 10:14:24 AM  
Kim Johnston

## Process Sheet

Split into  
8/07/12/03

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 34457 -1  
 Estimate Number : 12419  
 P.O. Number : NA  
 This Issue : 9/7/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : NA Type : SMALL /MED FAB  
 Previous Run : 30771  
 Written By : 07.09.07  
 Checked & Approved By : 07.09.07  
 Comment : Est Rev. A New Issue 06-05-23 EC

Drawing Name : TAIL LIGHT FAIRING  
 Part Number : D34842  
 Drawing Number : D3484 REV D  
 Project Number : N/A  
 Drawing Revision : D  
 Material : NA  
 Due Date : 9/14/2007

Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.3505 sf(s)/Unit Total : 3.5049 sf(s)  
 6061-T6 .050 Sheet  
 (M6061T6S050)  
 Batch: M17347

SAD 07/09/10

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3484  
 Dwg Rev: B  
 Prog Rev: D

2-Deburr if necessary

SAD 07/09/10

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/10

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07/09/10 (x11)

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr

SAD 07/09/10 (x11)

2-Roll as per Dwg D3484

→ ml 07/11/12 x11

(x9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/12/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 9/7/2007 10:14:24 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34457

Part Number: D34842

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 21.21.13 (x2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS*

*Handwritten:* PD 06.12.17 (9)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 4  
PD 07/12/18

Job Completion



*Handwritten:* pin 2007/12/17

*Handwritten signature*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







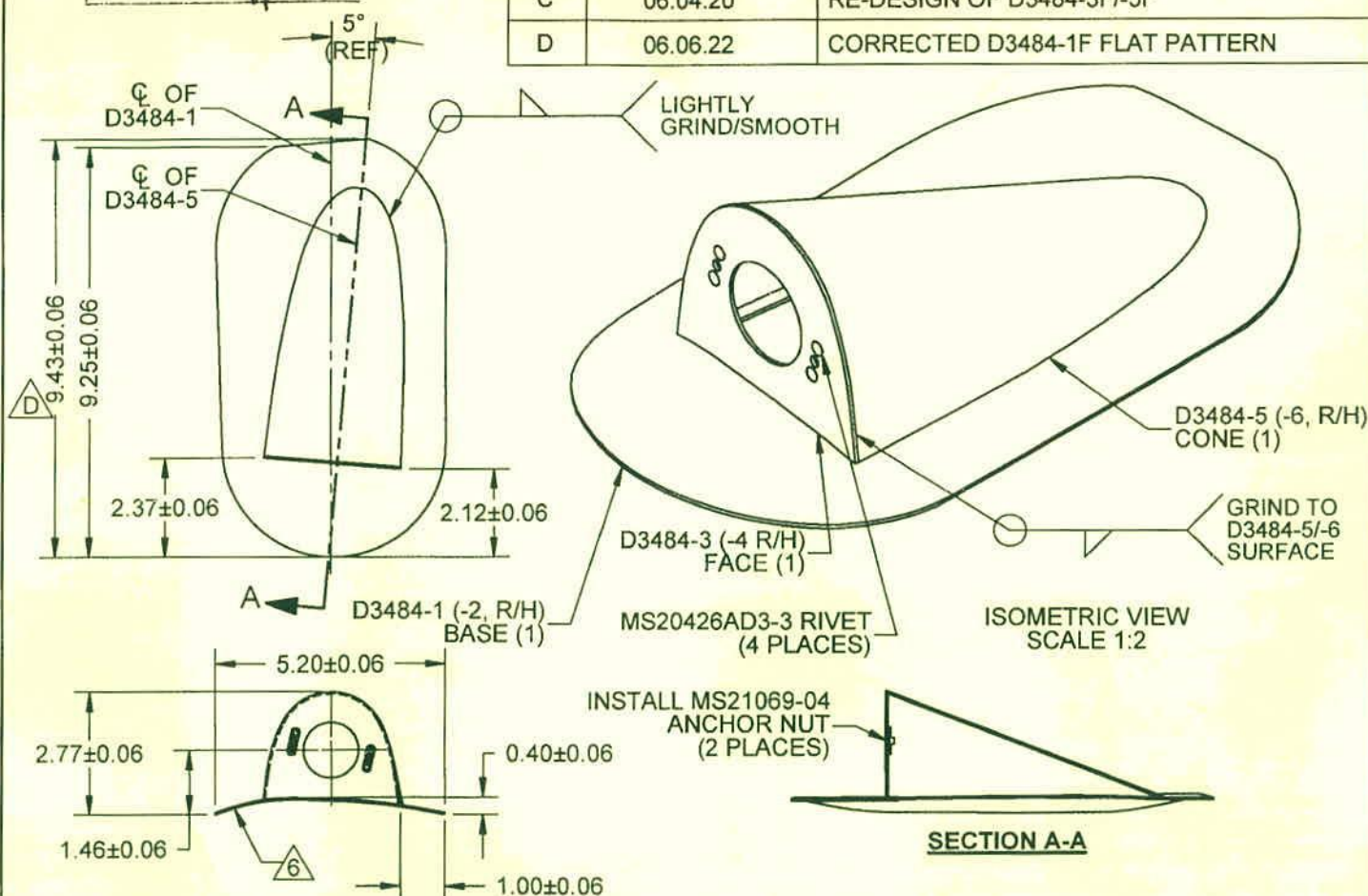


**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE	06.06.22	TITLE TAIL LIGHT FAIRING	SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

RELEASED

06.08.17

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD.,  
P/N D412-750-141/-142 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE  
PDA06-13"

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

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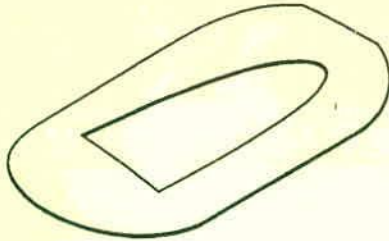
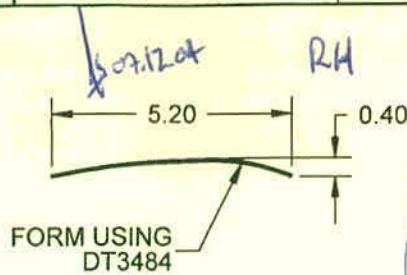
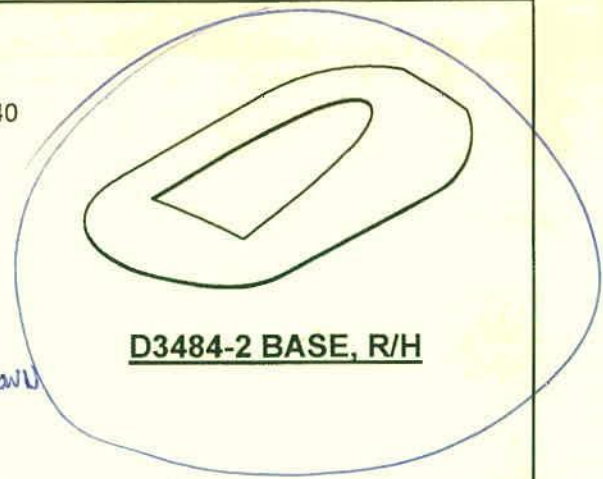
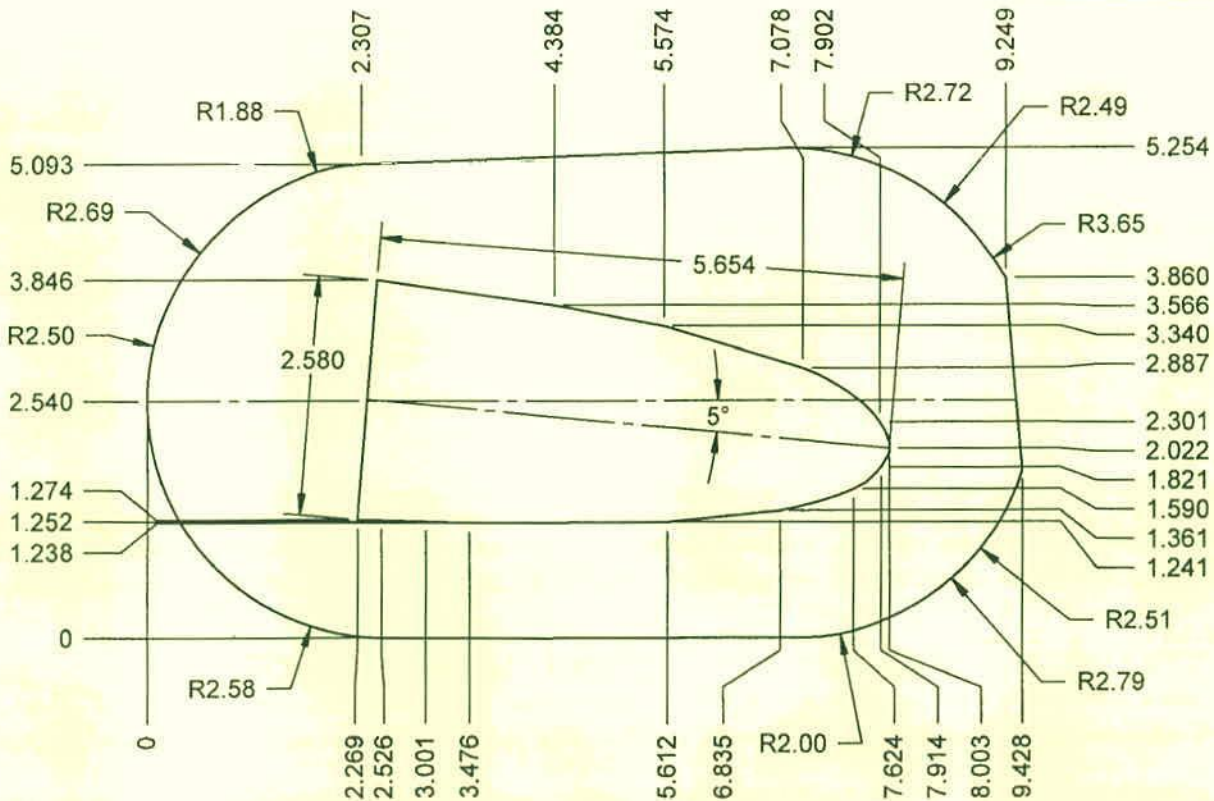
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3484</b>	REV. D SHEET 2 OF 4
DATE <b>06.06.22</b>		TITLE <b>TAIL LIGHT FAIRING</b>	SCALE 1:2

**D3484-1 BASE, L/H****D3484-1 BENDING DETAIL**  
(D3484-2 OPPOSITE)  
(MAKE FROM D3484-1F)**D3484-2 BASE, R/H****D3484-1F BASE FLAT PATTERN** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

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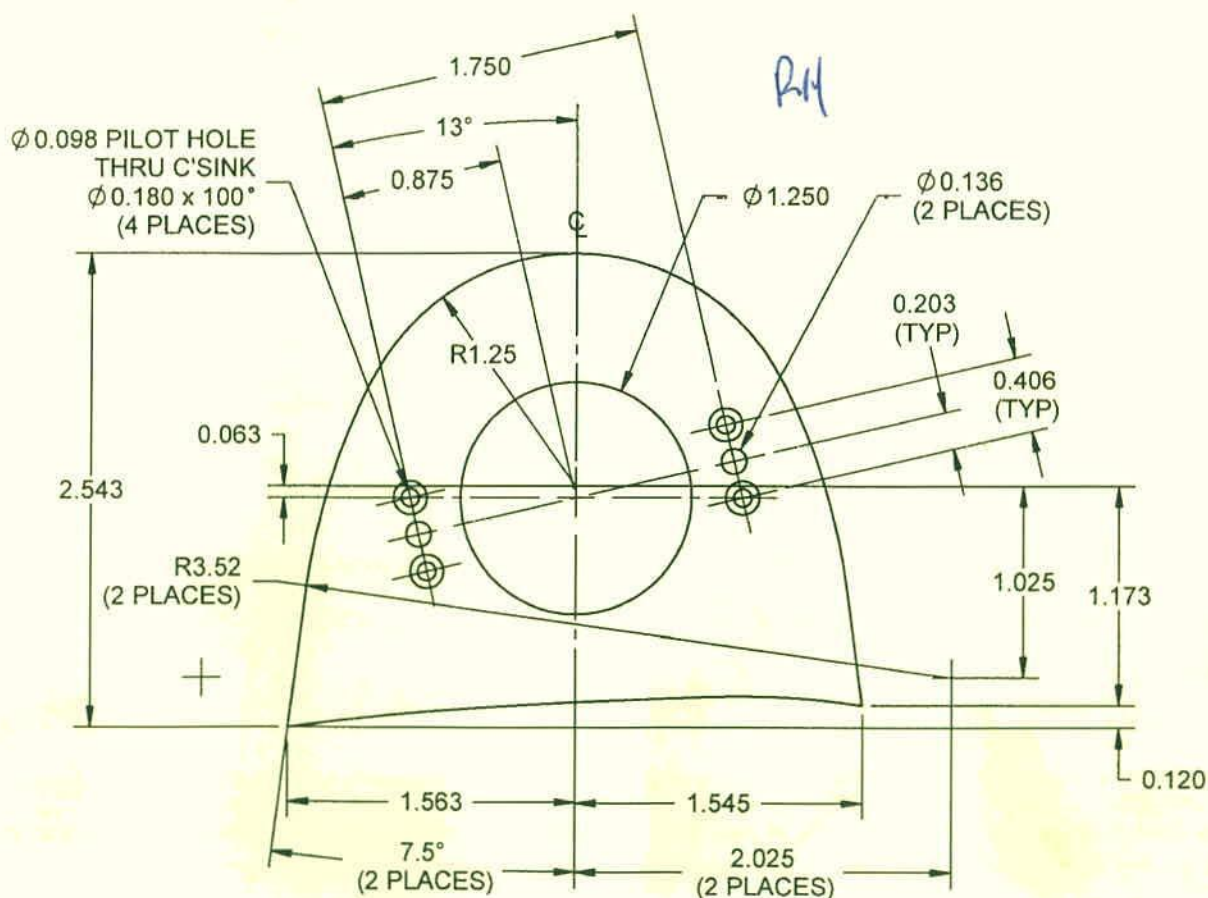
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DATE 06.06.22	TITLE TAIL LIGHT FAIRING		SCALE 1:1



**D3484-3 L/H FACE (-4 R/H, OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

06.08.17 *#*

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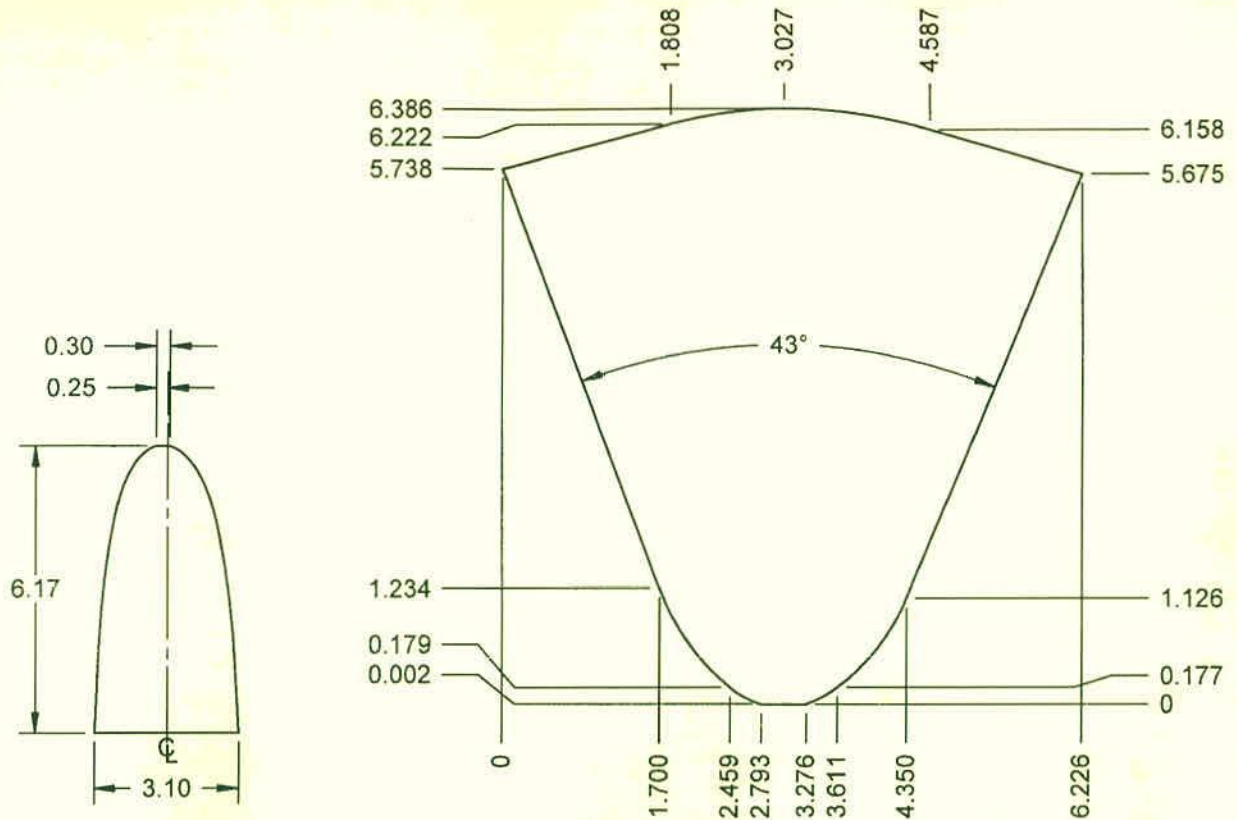
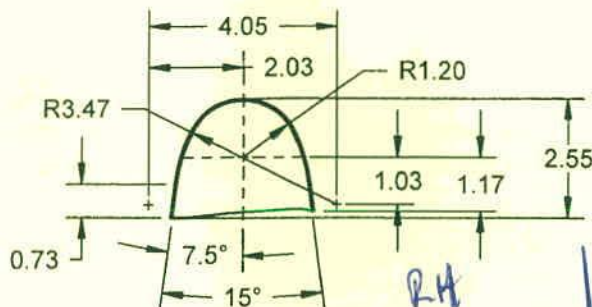
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DATE <b>06.06.22</b>		TITLE <b>TAIL LIGHT FAIRING</b>	SCALE 1:4

**D3484-5F CONE FLAT PATTERN****RELEASED**06.08.17 *H*

*NOT shown.* *SHAWN*

**D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)  
(MAKE FROM D3484-5F)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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